

Date: Thursday, 23/04/2009 7:24:14 AM
 User: Melanie Fauteux

Process Sheet

Customer : CU-DAR001 Dart Helicopters Services	Drawing Name : SEAT BELT GUIDE
Job Number : 47386	
Estimate Number : 13875	
P.O. Number :	Part Number : D39207
This Issue : 23/04/2009 S.O. No. :	Drawing Number : D3920 REVB PRELIM
Prsht Rev. : NC	Project Number : N/A
First Issue : / / Type : SMALL /MED FAB	Drawing Revision : B PRELIM
Previous Run :	Material :
Written By :	Due Date : 23/04/2009 Qty: 4 Um: Each
Checked & Approved By : <u>mf 09-04-23</u>	
Comment : Est Rev: A New Issue 09.04.22 EC verified: DD	

Additional Product

PRELIMINARY ISSUE 09.04.23

Job Number:



Seq. #:	Machine Or Operation:	Description :
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1.0	M6061T6S063	6061-T6 .063 Sheet
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Comment: Qty.: 0.0158 sf(s)/Unit Total : 0.0630 sf(s)
 6061-T6 aluminum sheet 0.063" thick
 Batch: 110551 IB 9-4-23

2.0	WATER JET	FLOW WATER JET
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Comment: FLOW WATER JET
 1-Cut as per Dwg D3920
 Dwg Rev: prf IB 9-4-23
 Prog Rev: Lim
 2-Deburr if necessary IB 9-4-23

⑨

3.0	QC2	INSPECT PARTS AS THEY COME OFF MACHINE
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Comment: INSPECT PARTS AS THEY COME OFF MACHINE

4.0	QC8	ENGINEERING APPROVAL
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Comment: SECOND CHECK

09.04.23 / S 02/04/23 (4)

5.0	SMALL FAB 1	SMALL & MEDIUM FAB RESOURCE 1
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Comment: SMALL & MEDIUM FAB RESOURCE 1

Form as per dwg D3920

SA 09/04/23

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes (No) DQA: D Date: 09/04/23
 Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			
09/04/23	5	1 piece was scrap because it's had to be modified	<u>[Signature]</u> 09/04/23 PER 05/04/23	Scrap + destroy	<u>So</u> 09/04/23	<u>S</u> 09/04/23	<u>[Signature]</u> 09/04/23 PER 05/04/23	<u>S</u> 09/04/23
		P.C Preliminary issues						

NOTE: Date & initial all entries

Date: Thursday, 23/04/2009 7:24:15 AM
User: Melanie Fauteux

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: SEAT BELT GUIDE

Job Number: 47386

Part Number: D39207

Job Number:



Seq. #:

Machine Or Operation:

Description :

6.0

QC5

INSPECT WORK TO CURRENT STEP



ENGINEERING
APPROVAL



Comment: INSPECT WORK TO CURRENT STEP

09-04-23 / 506423 (28)

7.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: _____

ST 261 cnt 09-04-24

8.0

QC21

FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

(8)
09/04/24

Job Completion



POSITIVE RECALL

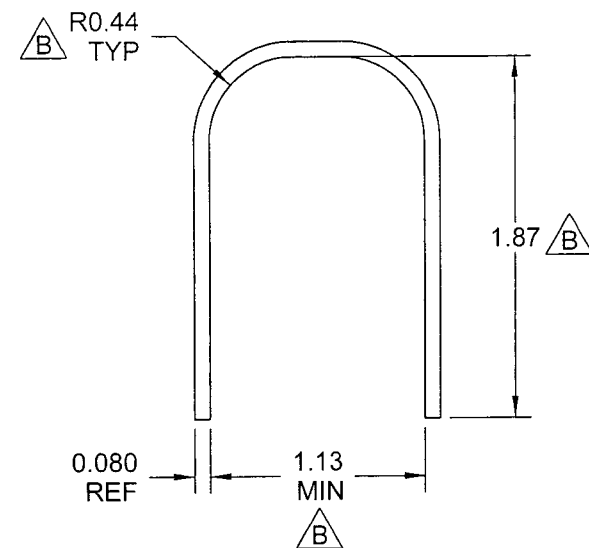
EFFECTIVE

RELEASED

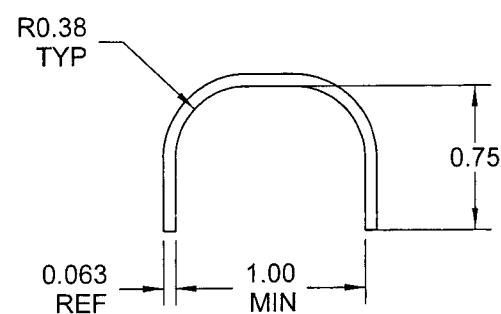
AUTH

DATE

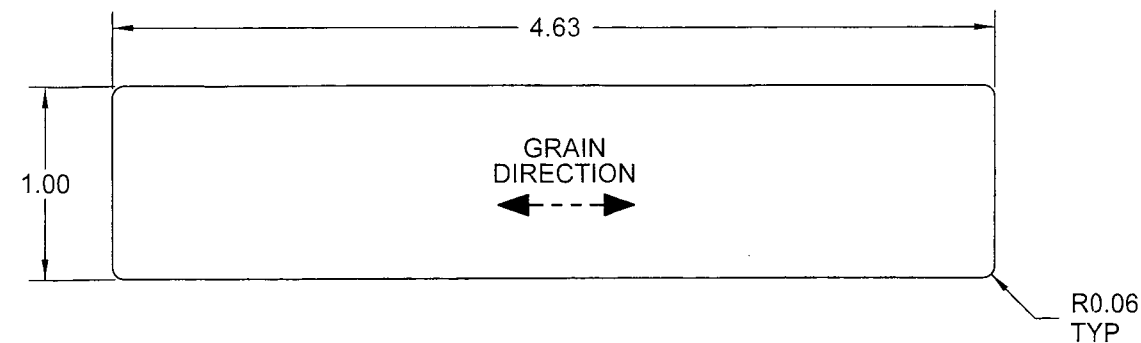
09-04-23
09-04-24
09.04.24



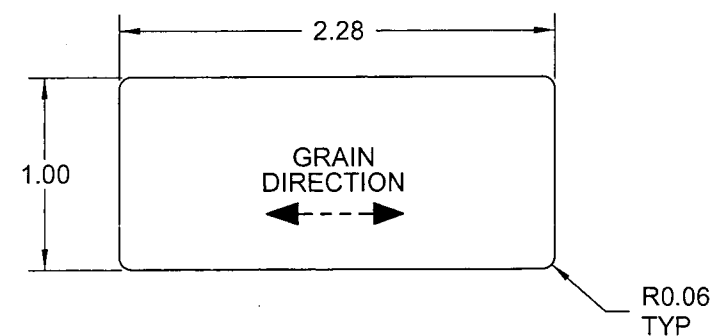
D3920-3 SEATBELT GUIDE BRACKET
(MAKE FROM D3920-3F)



D3920-7 SEATBELT GUIDE SHIM B
(MAKE FROM D3920-7F)



D3920-3F FLAT PATTERN



D3920-7F FLAT PATTERN

NOTES: D3920-3&-7

1) MATERIAL -3: 6061-T6 (OR T62) ALUMINUM SHEET 0.080 THICK
PER AMS-QQ-A-250/11
REF DART SPEC M6061T6S.080

-7: 6061-T6 (OR T62) ALUMINUM SHEET 0.063 THICK
PER AMS-QQ-A-250/11
REF DART SPEC M6061T6S.063

- 2) FINISH: NONE
3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
4) UNITS: INCHES UNLESS OTHERWISE NOTED
5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
6) IDENTIFICATION: N/A
7) WEIGHT -3: 0.04 lbs
-7: 0.01 lbs

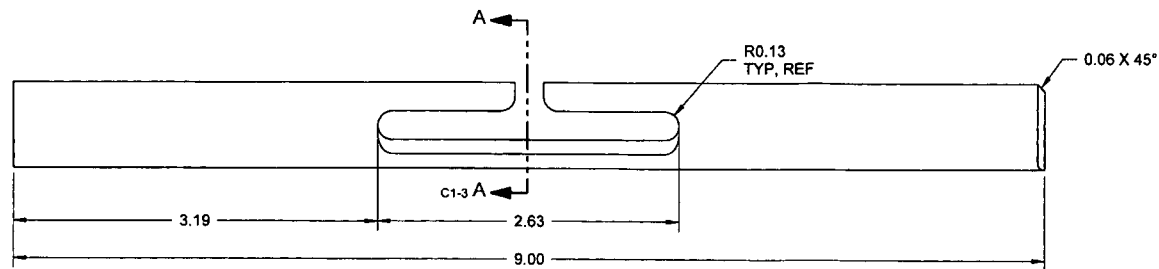
**PRELIMINARY
ISSUE**

AJS 09.04.22

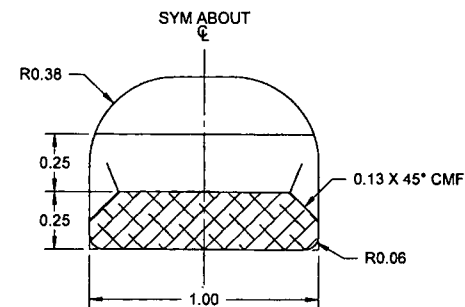
DESIGN	AJS	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN	AJS		
CHECKED	<i>[Signature]</i>	DRAWING NO. D3920	REV. B
MFG. APPR.	<i>[Signature]</i>	SHEET 4 OF 4	
APPROVED	<i>[Signature]</i>	TITLE	SCALE
DE APPR.		SEATBELT GUIDE ASSY (214B/B1)	NTS
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47386

8 7 6 5 4 3 2 1

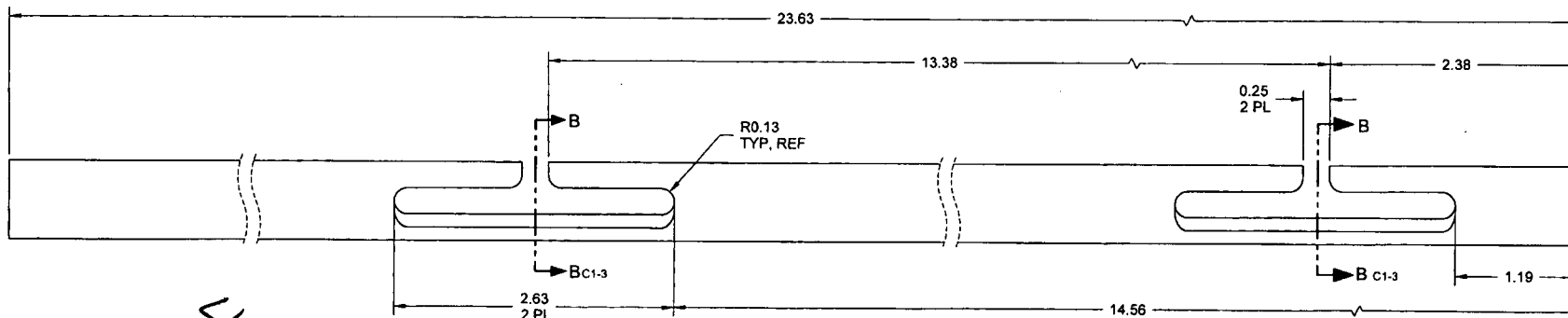


D3920-1 SEATBELT GUIDE



SECTION A-A C6-3
SCALE 2X

SECTION B-B B2-3
SCALE 2X B5-3







D3920-5 SEATBELT GUIDE

47386

NOTES: D3920-1&5

- 1) MATERIAL: 6061-T6 (OR T651/T6510/T62) ALUMINUM BAR
PER AMS-QQ-A-225/8 (OR AMS 4117/4128/4115/4116) OR AMS-QQ-A-200/8 (OR AMS4160)
REF DART SPEC M6061T6B
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: N/A
- 7) WEIGHT -1: 0.53 lbs
-5: 1.44 lbs

RELEASED
09/04/22

DESIGN	AJS	DART AEROSPACE LTD	
DRAWN	AJS	HAWKESBURY, ONTARIO, CANADA	
CHECKED		DRAWING NO.	REV. B
MFG. APPR.		D3920	SHEET 3 OF 4
APPROVED		TITLE	SCALE
DE APPR.		SEATBELT GUIDE ASSY (214B/B1)	NTS
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8 7 6 5 4 3 2 1